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Industrial Diamond Situation in the  
Soviet Zone of Germany

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INDUSTRIAL DIAMOND INDUSTRY IN EASTERN ZONE

ZEISS, JENA, is the only sizeable firm. According to trade gossip they employ 1,000 persons on diamond drawing - die manufacture and process between 30 and 40,000 carats per annum. They lack experience and skilled workers. Much of the work obtained by Ernst WINTER, GORNSDORF, was the repair of faulty diamond tools which had been supplied by ZEISS. The GORNSDORF Works employed only eight persons. Prior to 1945 they employed about 30

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There are no other firms except a few insignificant ones employing two or three persons. The GORNSDORF new production was about 600 carats per annum. The diamonds were supplied by the customers and obtained through ZEISS, JENA.

ORIGIN OF DIAMONDS

All the diamonds supplied were of South African or South American origin.

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The demand for diamond tools in Eastern Germany is far greater than the supply.

CUSTOMERS OF GORNSDORF

Though the orders were not large, the very fact that the customers could place them with a private firm and obtain the release of diamonds showed a very high priority. Customers and orders were:-

- a) HETTSTEDT S.A.G. Wire-drawing dies.
- b) LANDESGEOLOGIE, BERLIN Deep-drilling crowns. Wanted for NORDHAUSEN and Harz area.
- c) NILES-WERKE, WEISSENSEE Diamond grinding discs.
- d) UROFA Glass Works, SAXONY Large diamond abrasive wheels, stones for watch or instrument bearings.
- e) GEBRUEDER THIEL, RUHLA, Thuringia. Diamond abrasive wheels.
- f) Diamonds for ROCKWELL Hardness-Testing Machines. About 1,000 per annum. For various customers.

HARD-METAL TOOLS

developed the manufacture at GORNSDORF of hard-metal tools made from WIDEL, manufactured in LIEBELBORN. HETTSTEDT S.A.G. were willing to take as many dies for tube and profile drawing as the works could produce.

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PROPOSAL TO FOUND NEW INDUSTRIAL DIAMOND  
AND HARD-METAL TOOL WORKS

Early in 1951 [ ] the Economic Planning  
Section of the Land Government of Saxony with a view to expanding diamond  
tool production, and [ ] April 1951 [ ] signed an agreement with the  
Science and Technology Sub-Section of the Economic Planning Section whereby  
[ ] undertook to draw up proposals for a new State works for the manufacture  
of:-

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- a) Diamond saws
- b) " lathe tools
- c) " glass-cutting tools
- d) " tools for graduating glass
- e) " " trimming grinding wheels
- f) " grinding wheels.

The location of the new works was not decided upon. [ ]

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SUBJECT:- MARGARINE FACTORY "MILKA" AT PRATAU, NEAR WITTENBERG

1. DESIGNATION

The factory is termed "MILKA" and is an affiliated concern of the "MARGARINE UNION", Vereinigte Oel und Fettwerke A.G. (VVB-Z)

2. LOCATION

The margarine factory is situated South of the village PRATAU approximately 2.5 Km South of WITTENBERG on the main railway line BERLIN-HALLE. Coordinates are: 51°50'25" N 12°38' E Sheet P-7, AMS-1, LUCKENWALDE.

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4. RAW MATERIALS

a) Crude oil

The majority of the oils refined were 'Rüßöl', 'Mohnöl', and 'Senföl'. These oils arrived from the following places:

MAGDEBURG 30 tons daily  
RIESEA 20 tons daily  
GOTHA 15 tons daily  
WITTENBERG varied quantities.

The oil arrived in oil tankers by rail. In December 1950, deliveries of crude oil began to arrive from China. This Chinese oil consisting of approximately 14,000 tons up to February 1951 was of the ground-nut type. The oil was for use in margarine.

b) Fats

Approximately 55 tons of fat was delivered daily to the factory and came from the 'Hydrierwerke' RODLEHEN. The fat was delivered in railway tankers in a fluid condition having been heated prior to despatch.

c) Approximately 120 tons of vegetable oil and 55 tons of fat was refined daily at the factory.

5. STORAGE

The factory had a maximum storage capacity of 10,000 tons of oil. One tank contained 400 tons, three tanks 200 tons and six tanks 40 tons each. Large numbers of barrels were also used for storage.

6. PRODUCTS

The normal daily production figure was:

Margarine 80 - 100 tons  
Salad Oil 12 tons

Approximately 125 - 200 tons of refined oil was despatched daily to smaller margarine factories in the ROZ.  
Further daily products were:-

Adipic acid 6 - 7 tons  
Soap 7 tons

Between 160 - 180 tons was the maximum daily production figure for margarine.

## 7. DESPATCH OF PRODUCTS

The majority of the finished products were despatched to the H.O. Main Store and Cooperative Societies in the principal towns of the ROZ.

The cost of manufacture of 1 lb of margarine was	- 65 Pf	O.M.
Sale price in retailers on ration card	1. 20	"
H.O. shop price	5. 0	"

Refined oil was delivered to the following places:

CHEMNITZ	80 tons weekly
ROSTOCK	60 tons weekly
DRESDEN	varied quantities
DORNWITSCH	varied quantities

## 9. TECHNICAL PROCESS

The crude oil is pumped into huge boilers in the refinery and approximately 0.6 - 0.8% of water added. It is then heated to 50 - 90° and mixed. Natron hydroxide is then added and the mixture left for 4 hours. The vegetable oil is then washed. The washing process is carried out three to nine times according to the cleanliness of the oil. The oil is treated in a vacuum set by 80° centigrade to remove all water, and after this process it is treated in the same container with three to four percent 'Bleicherde' at 60 to 90 degrees and steadily stirred during this treatment, which lasts from 30 minutes to 2 hours. After this process the 'Bleicherde' (bleaching agent) is removed by means of filter presses. The pure oil is collected in tanks and from there sucked into the condenser. The condenser is a vacuum set in which the oil under addition of citric acid at the ratio of 0.5 litres citric acid to 0.5 tons of oil is treated by super-heated steam of a temperature of 370° for 6 to 9 hours. From this apparatus the oil is transported to pure oil tanks.

The oil gained is now despatched either as salad oil or as basic oil for margarine production. The majority of the latter substance going to the margarine factory adjoining the Plant. In the margarine factory the oil is mixed with HARTMUT (solidifying fat) at a fixed ratio. The desired ratio is 40 % solidifying fat to 60 % oil. The fat/oil substance is mixed with water and 1 % 'Emulgator' supplied from 'Rodleben' salt and butter colouring. This substance then passes over ice cooled drums with a temperature of minus 18 degrees for stabilisation of the emulsion and then is treated in several kneading machines. Having passed the kneading machines a potatoe-flour and water mixture and artificial flavouring is added. The artificial flavouring consisted of diazethyl or a diazethyl base mixed with esthers. After this processing the margarine undergoes a cooling and ripeness process and then is cut into cubes and wrapped in grease proof paper.

## 10. INFORMATION ON LABORATORY TESTS

Nearly all laboratory tests were carried out by the 'Zentral Laboratorium fuer Ernährung' at MAGDEBURG (central food laboratory). Informant knows of the following details of laboratory tests carried out in the works:

- tests on several types of solidifying fats for margarine manufacture
- tests on new methods of judging utility of oils for margarine manufacture
- tests on replacing the artificial butter colouring by 'Carottin'

## 11. 'BOTTLENECKS' CAUSED BY LACK OF SPARE PARTS AND RAW MATERIALS.

### 1) Spare Parts

Spare parts for the two filter pumps are not available in the ROZ. The VEB refused to take over manufacture of spare parts for these pumps which were built in Western Germany. According to Informant, the break-down of the pumps will stop the whole production process and will cause a break-down of the margarine supply of the ROZ, as all other margarine factories are dependent on supplies of raw materials from this plant.

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Further delay occurred in the lack of supply of armatures, valves and seamless tubes for oil and steam pipes. Due to the scarcity of cotton in the ROZ, it is impossible to manufacture filters. Tests are carried out to replace cotton filters by Perlon filters. The quality of the margarine could be improved by prolonging the process of ripeness. The containers in which this process takes place, the so-called 'Butterwagen' cannot be obtained in the ROZ as they are made from V2A-steel which is not available. The factory needs about 40 of these containers. Difficulties of transporting the oil is due to the fact that there are not enough railway tank cars.

ii) Raw Materials

The supply of natron hydroxide is inadequate, citric acid is not available in the ROZ [REDACTED]

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[REDACTED] The supply of solidifying fats is also inadequate in the ROZ, therefore the works are not able to obtain the desired mixture of fat and oil. [REDACTED]

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the 'Deutsche Hydrierwerke' at RODLEBEN is the only works capable of manufacturing solidifying fats in large quantities. The supplied fat is of a poor quality, due to the fact that RODLEBEN has no suitable [REDACTED] for the production process, and as the works is compelled to carry out the processing on a nickel-carbonate basis as nickel- 50X1-HUM formiat is not obtainable, the result being that there is no selective hardening.

12. ELECTRIC POWER

The factory has no power generating plant but is supplied with power from unknown sources by means of underground cables. The power consumption is 6,000 KW per day.

13. COAL CONSUMPTION

About 400 tons of coal are consumed per day. Coal is supplied from NACHTERSTEDT, AMMENDORF and some from BERGWITZ.

14. SAFETY MEASURES

The factory has its own fire brigade equipped with one fire engine. Fire extinguishers are in all rooms of the factory. There are no special fire precautions for the oil tanks.

15. DEFENCE

There is no strict control of the factory. All workers entering the factory had to sign their name in a book in the porter's office. At night the factory compound was guarded by one porter with a watch dog.

16. LABOUR

Total number of employed workers was 400. Work in the plant was carried out in three shifts, 8 hours a day, 7 days a week, with the exception of the margarine factory which worked in two shifts of 8 hours a day, 6 days a week.

17. WORKS DIRECTION

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Werksleiter (head of works) and at the same time 'Treuhaender' is HERNE [REDACTED]

Personnel Chief is GUNTTLER, 'Obermeister'

(Chief Master) of refinery is Wilhelm WINKLER. [REDACTED]

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18. DEUTSCHE HYDRIERWERKE AT RODLIEBEN NEAR DESSAU

A short time ago a so-called PO installation for oxidation of paraffin and manufacture of synthetic adipic acid was installed.

Main product is Tetralin of a naphthalene basis and manufacture of pharmaceuticals. The works has its own research laboratories and cooperates with the textile industry.

19. SOLIDIFYING FAT WORKS

A new factory manufacturing solidifying fats has been established at BERLIN-LICHTENBERG. This VEB factory supplies small margarine factories. The daily output at the moment is 10 tons per day, as the factory has technical difficulties in production process and also due to the fact that not enough hydrogen is available. It is planned to increase output to 40 tons per day in the future.

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SUBJECT:- TURBINE INSTALLATION AT POWER STATION AT AUMA (THUR)

1. LOCATION

The power station is situated on the western outskirts of AUMA and slightly South of the railway station of AUMA. Coordinates are 50°42' N, 11°53'45" E

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3. DESCRIPTION

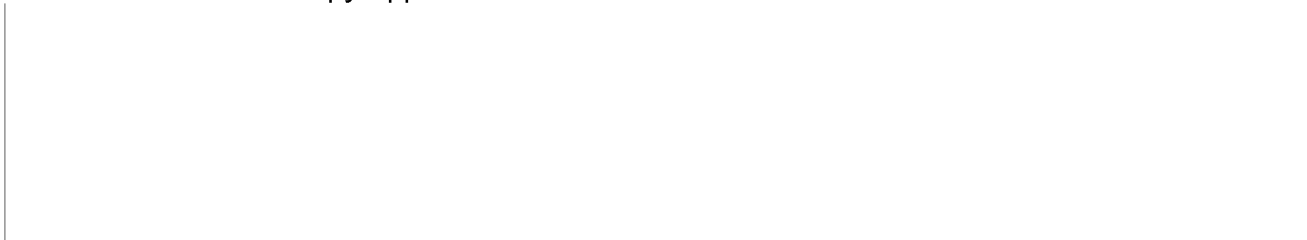
The power station, was powered by 3 steam boilers heated with coal. The station had three turbines of 500 KW and 1 of 1,500 KW. In September 1950, the third turbine was installed and began operation [redacted] 1951. This new turbine had a maximum capacity of 4,500 KW. The turbine was produced by BROWN ' BOVERIE, MANNHEIM.

The station had one large building 100 x 50 m and approximately 15 m high. Half of the building served the purpose of turbine house and the other half boiler-house. Attached to the main building was an administration building.

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KEY TO SKETCH "A"

1. Building. 3 storied - 30 m long
2. Turbine Room.
  - a) Turbine recently installed 4,500 KW
  - b) Turbine 1,500 KW
  - c) 1 turbine of 500 KW
3. Boiler house with 3 boilers
4. Old chimney, 80 m high
5. New chimney, 96 m high
6. Wooden construction previously used as cooling tower now serving the purpose of a store shed
7. Transformer house, 30 m long, 8 m diameter
8. Overhead high tension cables.



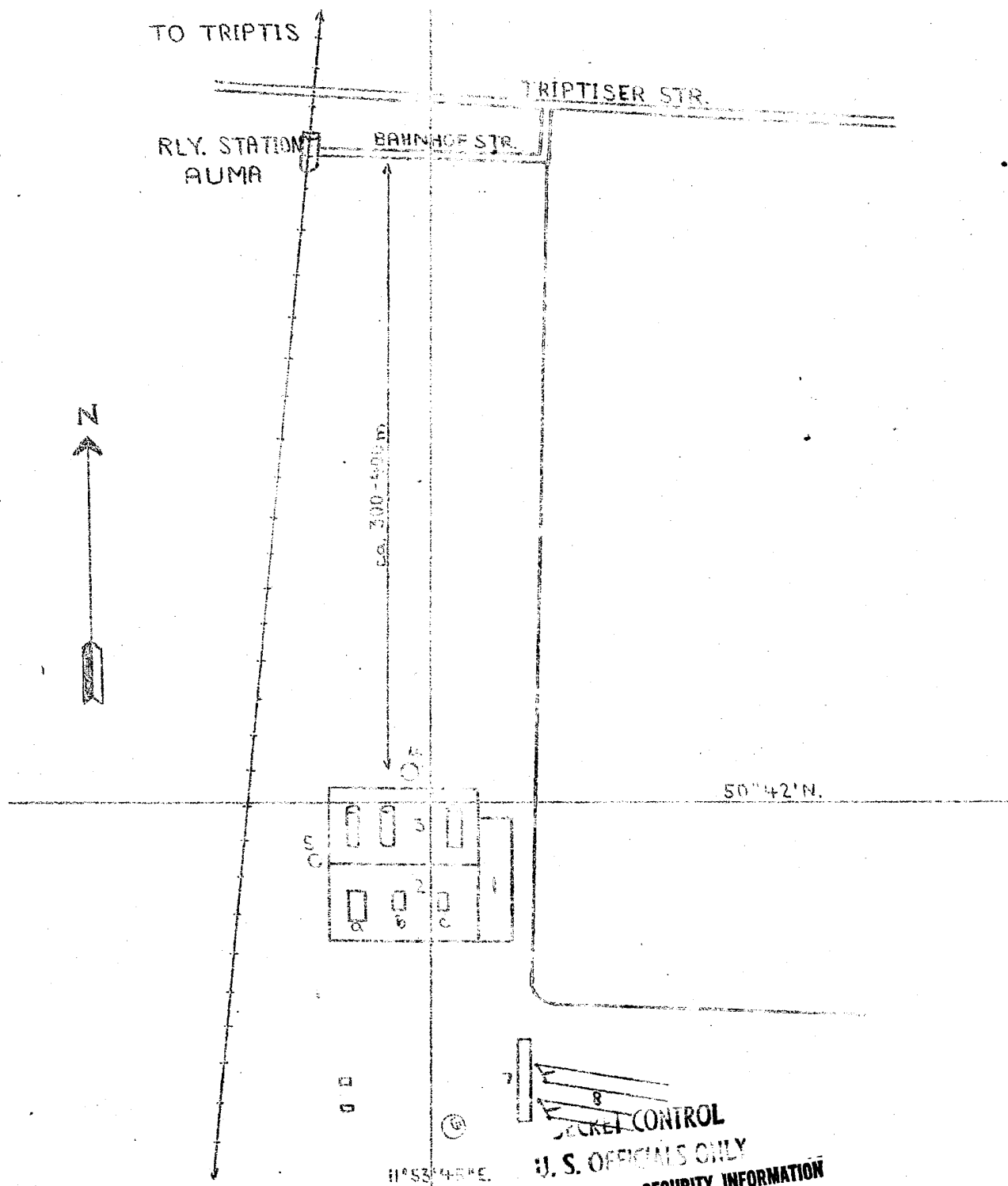
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## TURBINE INSTALLATION AT POWER STATION AT AUMA (THUR.)

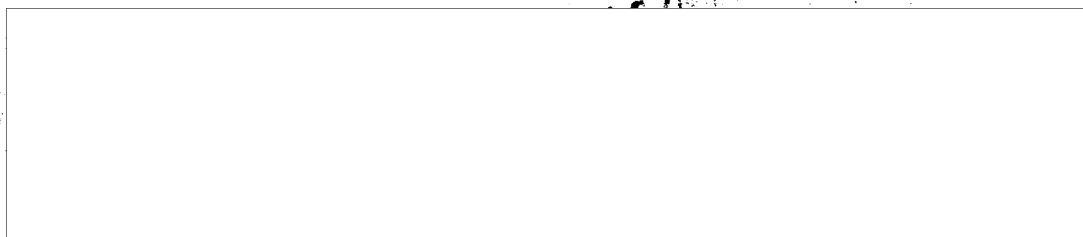
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SKETCH A



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KEY TO SKETCH "A"

1. Margarine factory
2. Refinery
3. Margarine despatch store
4. Boiler house with 3 water tube boilers of which 2 are operated
5. Refrigerator machine house
6. Laboratory
7. Soap factory
8. Card-board box factory
9. Box factory
10. Store with first floor
11. Laundry, medical rooms and fitting shops
12. Closed store for drums
13. Fitting shops, with tool store on first floor
14. Garages
15. Fields
16. Meeting and dining rooms
17. Administration building with ground floor only
18. Porter
19. Bicycle shed
20. Dwellings
21. Open shed
22. Dog shed
23. Store shed
24. Processing of waste fat
25. Straw and hay store
26. Stables
27. Tank storage with 1 oil tank of 400 tons, 3 of 200 tons and 6 of 40 tons
28. Open air storage of oil drums
29. Coal reserves
30. Brick chimney 72 metres high
31. Railway sidings with turn disc
32. Railway branches 300 metres long for parking of railway tank car trains
33. Brick wall 2 metres high
- 33a) Wire fence 2 metres high.

KEY TO SKETCH "B"Ground floor of refinery building

- A. Lower part of damper installation
  1. Pure oil weighing machines
- B. Engine room
  2. Vacuum pumps for removing acids
  3. Main vacuum pumps for damper installation
  4. Filtered oil weighing machines
  5. Filter pumps
  6. First stage vacuum pump for damper installation
  7. Reserve compressor
  8. Compressor
- C. Emptying room for filtered bleaching agent (Bleicherde)
- D. Melting room for margarine sent back by the automatic packing devices when margarine is not satisfactorily solidified
  9. Pump
  10. Melting bins
- E. Adipic acid department, lower part
  11. Disintegration containers
  12. Setting containers.

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- F. Removing of acids department, lower part.
    - 13. Emulsion pump
    - 14. Pump for ductile emulsion
  - G. Tank room
    - 15. Tanks for raw oil
  - H. Store for bleaching agents (Bleicherde), Aktiv-Kohle, salt and sodium
    - 16. Cellar for 2 raw oil pumps
    - 17. Tanks for natron hydroxide
  - I. Yard
    - 18. Horizontal vessel for concentrated sulphuric acid
    - 19. Staircase
    - 20. Railway siding for railway tank cars

Stairs

- a) Staircase to first floor
- b) Staircase to centre gallery
- c) Staircases to small galleries
- d) Staircase to cellar for raw oil pumps
- e) Staircase to first floor
- f) Staircase to first floor, and store of bleaching agents (Bleicherde)
- g) Staircase to cellar for natron hydroxide

KEY TO SKETCH "C"Centre gallery of refinery

- A. Damper installation centre part
  - 1. Containers each of 6.5 tons capacity
  - 2. Containers each of 16.5 tons capacity
  - 3. Tanks for solidifying fat to be steamed
  - 4. 'Puffer' tanks for oil to be steamed
  - 5. Gangway
  - 6. Filter presses
  - 7. Passage (gangway to oil and fat tanks of margarine factory)
  - 8. Panels
- a) Staircase to first floor
- b) Staircase from  gallery to ground floor

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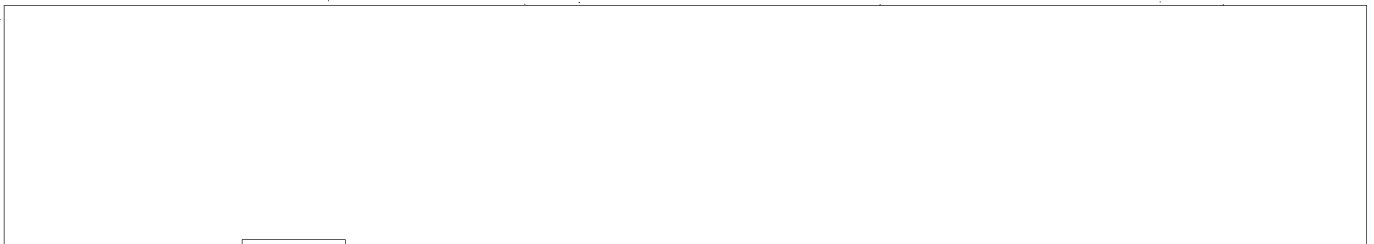
KEY TO SKETCH "D"Refinery - First floor



- A. Damper installation upper part
  - 1. Containers each of 6.5 tons capacity
  - 2. Containers each of 16.5 tons capacity
  - 3. Tanks for solidifying fat to be steamed
- B. Four hot water containers
- C. Acid removing installation (upper part)
  - 5. Horizontal vacuum bleacher
  - 6. Lye container
  - 7. Vertical vacuum bleacher
  - 8. Open soap boilers
  - 9. Closed emulsion containers
  - 10. Closed apparatus for acid removal.
  - 11. Closed apparatus for acid removal

Apparatus 8 to 10 - operated from ground floor only.

- 12. Universal apparatus system BEMAG of 42 tons each
- 13. Separator
- 14. Openings in galleries


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- D. View to  gallery
- 15. Filter presses (see also Sketch "C")
- 16. Balcony for control of  gallery
- E. Adipic acid department upper part (small gallery)
- 17. Split containers
- 18. Setting containers
- 19. Opening
- 20. Passage from small gallery to staircase
- F. Laundry and repair shop for filter linen
- 21. Lift from bleaching agent store
- G. Dining room
- H. Laboratory
- I. Office of Chief mater ('Obermeister')
- K. Wardrobe

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Stairs

- a) Staircase to first floor
- b) Staircase from ground floor to  gallery
- c) Staircase to small gallery
- d) Staircase to first floor
- f) Staircase from first floor to bleaching agent store
- h) Staircase to container gallery for chemicals situated above apparatus 11 and 12
- i) Staircase to lower gallery
- k) Stair to condensers in attic

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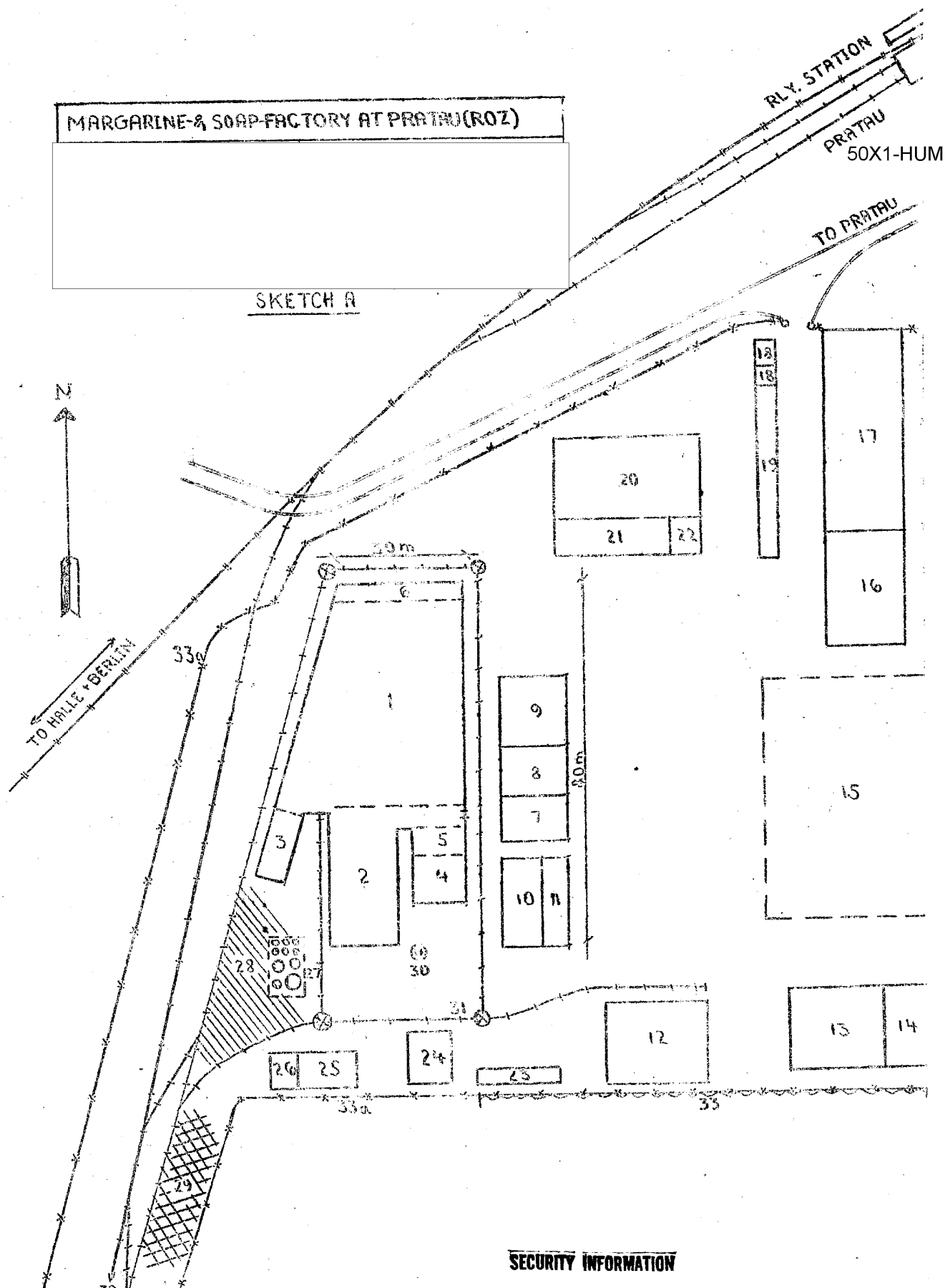


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MARGARINE & SOAP FACTORY AT PRATAU (ROZ)

SKETCH A

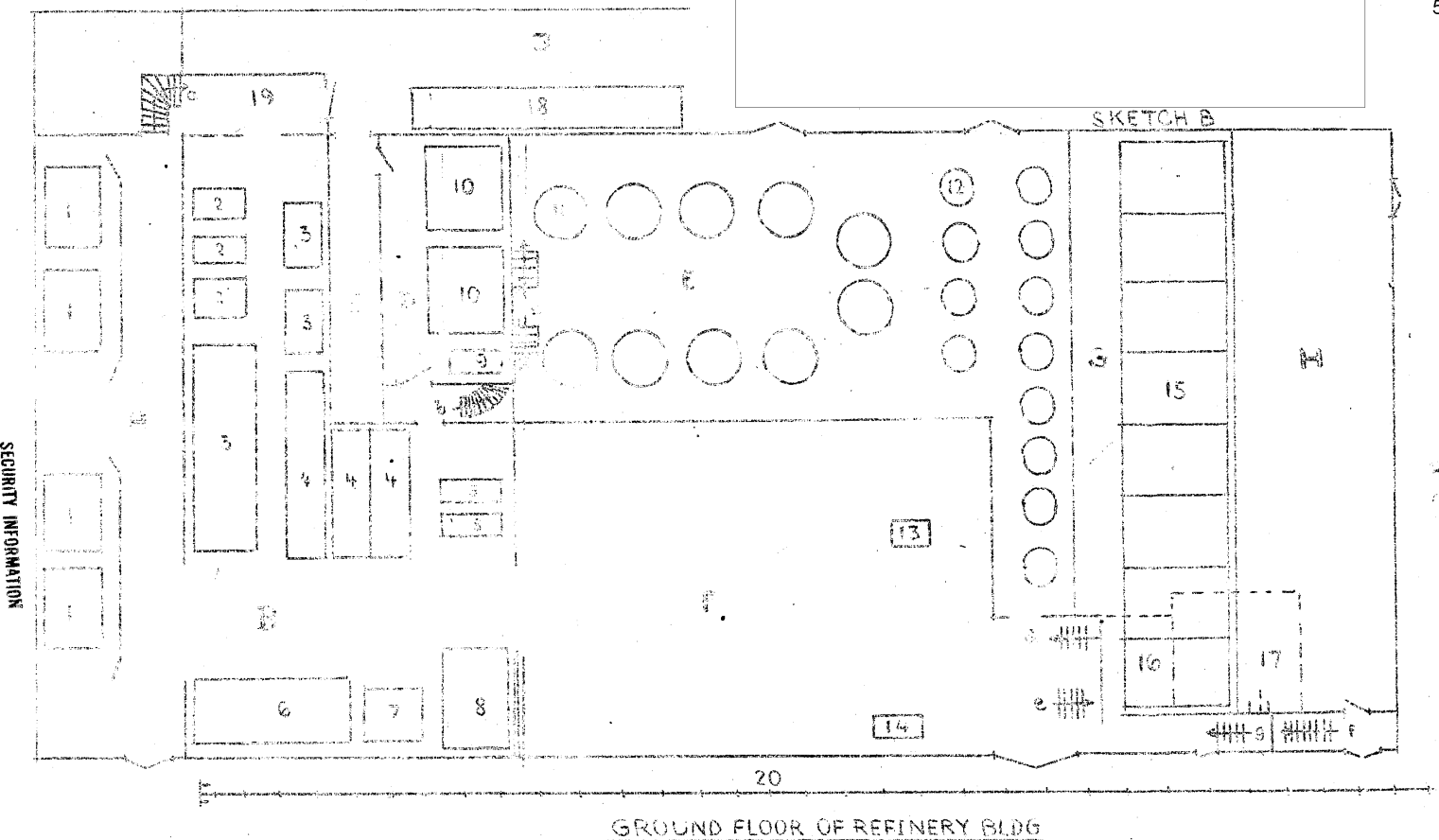


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MARGARINE- & SOAP-FACTORY AT PRATAU (R02)

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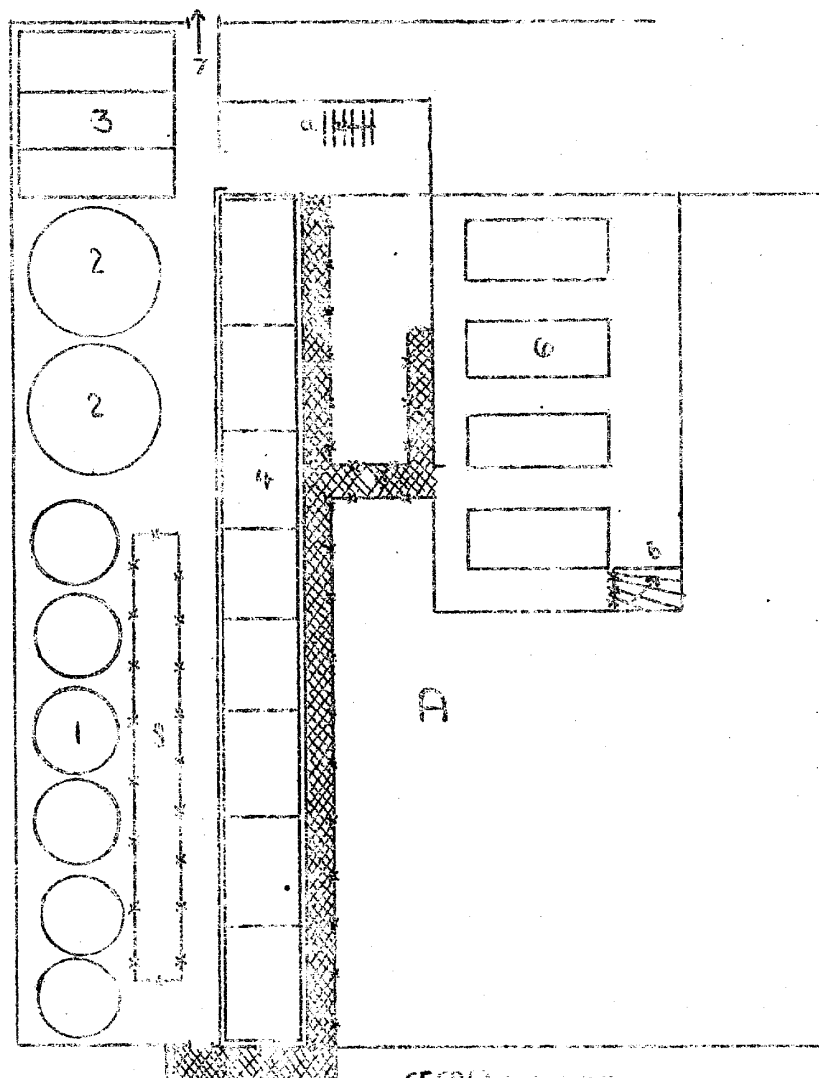
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MARGARINE- & SOAP-FACTORY AT PRATAU (ROZ)

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SKETCH C  
GALLERY OF REFINERY



SECRET CONTROL

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MARGARINE & SOAP FACTORY AT PRATAU (ROZ)

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REFINERY FIRST FLOOR

SKETCH D

